

Op No	Operation	Qty	Start Date	Due Date	Setup Run Hrs	Worker/Supplier	Lead Time	Sign-off
90	Start up Operation	5 Ea	1/25/18	0.00	0.00	Start Up Large Fab-4		CPC
110	Large Fab	5 pcs	1/25/18	0.00	4.96	Large Fab 2		CPC
120	QC	5 pcs	1/25/18	0.00	0.00	QC9		10 18-01-20
130	QC	5 pcs	1/25/18	0.00	0.00	QC5		10 18-01-20
140	HandFinish	5 pcs	1/25/18	0.00	0.92	HandFinish1		2018/01/22/25
150	QC	5 pcs	1/25/18	0.00	0.00	QC7-2		10 18-01-24
180	Large Fab	5 pcs	1/25/18	0.00	4.96	Large Fab 2		10 18-01-24
190	QC	5 pcs	1/25/18	0.00	0.00	QC10		38 DAS
200	QC	5 pcs	1/25/18	0.00	0.00	QC5		38 DAS
210	HandFinish	5 pcs	1/25/18	0.00	0.92	HandFinish1		2018/01/25/27
220	Powdercoat	5 pcs	1/25/18	0.00	1.45	Powdercoat1		10 18-01-24
230	HandFinish	5 pcs	1/26/18	0.00	0.92	HandFinish3		38 DAS
240	QC	5 pcs	1/26/18	0.00	0.00	QC3		10 18-01-24
250	Packaging	5 pcs	1/26/18	0.00	0.00	Packaging1-3		10 18-01-24
260	QC	5 pcs	1/26/18	0.00	0.00	QC4		10 18-01-24
265	DC	5 pcs	1/26/18	0.00	0.00	DC		10 18-01-24
270	Packaging	5 pcs	1/26/18	0.00	0.00	Packaging3-1		10 18-01-24
280	QC21-FG	5 Ea	1/26/18	0.00	0.00	QC21		10 18-01-24

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod

Descriptions: D3272 A/R Aluminum Rod

3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod

6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 2:35

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

Wing work. M138711

Job Allocations

Operation Component Part Required Inventory Allocated Std Qty

Job Routing

Bill of Materials

Part No: D350-591-311 **Job Qty:** 5 ea
Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Part Weight: 0 lbs
Job Created: 1/4/18
Due Date: 1/26/18
Type: SOLD
Description:
Customer: Airbus Helicopters - Marignane (CEURO24)
 Aeroport International De Marseille Cedex Marignane Marseille, 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.
Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC
 * Air BUS. *



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DART
AEROSPACE

D350-591-377
Job Sheet 169946



Σ1000

P

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

90-Start up Operation	D3067-1 - 5030168	5	18	0	0
	x2 → S033365 → D3219-1 - 5026612 → 8x	10	54	0	0
	D3272-1 - 5032336	5	0	0	0
180-Large Fab	D3065-041	5	14	0	0
	* D3066-1 5012395 ✓	10	90	0	0
	D3067-1 5030168 ✓	5	18	0	0
250-Packaging	MS20600-AD4W4	80	1,447	0	0
	AN3-35A	10	268	0	0
	AN4-13A	40	1,299	0	0
	AN5-36A	10	194	0	0
	D2230-3	20	179	0	0
	D2618	10	190	0	0
	D2856-400-720	10	185	0	0
	D3235-1	10	67	0	0
	D3278-041	5	23	0	0
	MS21042L3	10	3,336	0	0
	MS21042L4	40	3,684	0	0
	MS21042L5	10	759	0	0
	NAS1149D0363J	20	4,434	0	0
	NAS1149D0463J	80	5,772	0	0
	NAS1149D0563J	20	1,319	0	0

Part Specifications

Specifications could not be found.

Plex 1/4/18 8:43 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date: _____ Descr: _____		AGAINST DEPARTMENT/PROCESS <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">Cross tube</td> <td style="width: 33%;">Water Jet</td> <td style="width: 33%;">Engineering</td> </tr> <tr> <td>Small Fab</td> <td>Prod. Eng. Coord.</td> <td>Quality</td> </tr> <tr> <td>Finishing</td> <td>Rec/Store/Packaging</td> <td>Other</td> </tr> <tr> <td>Composite</td> <td>Supplier</td> <td></td> </tr> </table> MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval Disposition		Cross tube	Water Jet	Engineering	Small Fab	Prod. Eng. Coord.	Quality	Finishing	Rec/Store/Packaging	Other	Composite	Supplier	
Cross tube	Water Jet	Engineering													
Small Fab	Prod. Eng. Coord.	Quality													
Finishing	Rec/Store/Packaging	Other													
Composite	Supplier														
Start up Operation 01/19/18 Job No: 169946 Start up Operation CHG002 D350-591-311 Original Serial #: S033921 Revision: Operation: Change No:															

FAULT CATEGORY <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;"> Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified </td> <td style="width: 50%;"> Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due </td> </tr> </table>		Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified	Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;"> Temperature/Cure /Route en/Damage/Defect ection Incomplete/Unqualified ntamination ountersink ut Too Short nstructions Incomplete/Unclear Drill Holes </td> <td style="width: 50%;"> Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center </td> </tr> </table>		Temperature/Cure /Route en/Damage/Defect ection Incomplete/Unqualified ntamination ountersink ut Too Short nstructions Incomplete/Unclear Drill Holes	Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center
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Heat Treat Wave/Twist in Tube Marks/Chatter		Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence					



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Master Unit 000113

Tel (613) 632-5200

Containers on Master Unit 000113				
Serial No	Part No	Customer Part No	Status	Quantity
S037276	AN3-35A		Allocated	10
S037266	AN4-13A		Allocated	40
S024840	AN5-36A	AN5-36A	Allocated	10
S026865	D2230-3	D2230-3	Allocated	4
S037247	D2230-3	D2230-3	Allocated	2
S037248	D2230-3	D2230-3	Allocated	14
S037243	D2618	D2618	Allocated	10
S037242	D2856-400-720	D2856-400-720	Allocated	10
S035792	D3065-041	D3065-041	Allocated	0
S032705	D3066-1	D3066-1	Allocated	0
S035791	D3066-1	D3066-1	Allocated	0
S037239	D3235-1	D3235-1	Allocated	10
S037236	D3278-041	D3278-041	Allocated	5
S035789	MS20600-AD4W4		Allocated	0
S035107	MS21042L3	MS21042L3	Allocated	17
S037225	MS21042L4	MS21042L4	Allocated	40
S037224	MS21042L5		Allocated	10
S037223	NAS1149D0363J	NAS1149D0363J	Allocated	20
S037222	NAS1149D0463J	NAS1149D0463J	Allocated	80
S037219	NAS1149D0563J	NAS1149D0563J	Allocated	20

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-38A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.